

**DART**

DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. DSI 9356	REV. A SHEET 1 OF 2
DATE 06.09.28		TITLE ELONGATED HOLE REPAIR SCHEME	SCALE NTS
A	06.09.28	NEW ISSUE	

# **DART SERVICE INSTRUCTION**

TO AMEND INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D350-607

REF. CANADIAN STC: SH94-14

FAA STC: SR00213NY

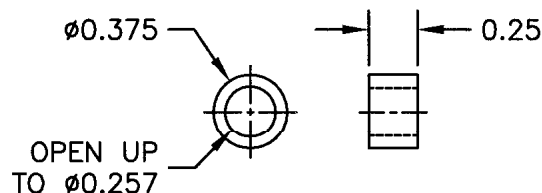
In cases where the mounting holes at the base of the basket are elongated due to wear or damage, it is acceptable to repair the holes by enlarging the holes in the D2325 Gussets to  $\varnothing 0.375$ " (3/8" drill) and welding a 0.375" OD x 0.065" wall x 0.25" long bushing to the basket gusset(s) as outlined below, and installing longer bolts or quick release pins.

## **Repair Procedure:**

- 1) Machine bushings as per Figure 1.
- 2) By referring to Figure 2, enlarge thru holes using a 3/8" drill. Deburr sharp edges and remove paint around holes as shown.
- 3) Install bushings by T.I.G. welding per MIL-STD-2219/AMS-STD-2219 Class 'C' using ER308L filler rod as per Detail B of View A-A.
- 4) Touch up paint in accordance with ICA-D350-607.
- 5) When the basket base is repaired, longer bolts or quick release pins are required to install the basket. Substitute existing bolts or quick release pins as per Table 1:

**Table 1**

Bolt		Positive Quick Release Pin	
Existing	Replacement	Existing	Replacement
AN4-12A	AN4-15A (Ensure 1.5-4 threads remain)	BLRS-010 (1" Min. Grip)	BLRS-020 (1.5" Min. Grip)



## **BUSHING MATERIAL:**

AISI 304/316 STAINLESS STEEL SEAMLESS TUBING, 0.375 OD X 0.065 WALL

**FIGURE 1: BUSHING DETAIL**

CANADA  
DEPARTMENT OF TRANSPORT  
AIRCRAFT CERTIFICATION  
BRANCH  
DAO # 01-O-01

## **APPROVED**

BY: *[Signature]*  
D. SHEPHERD (DE # 02)

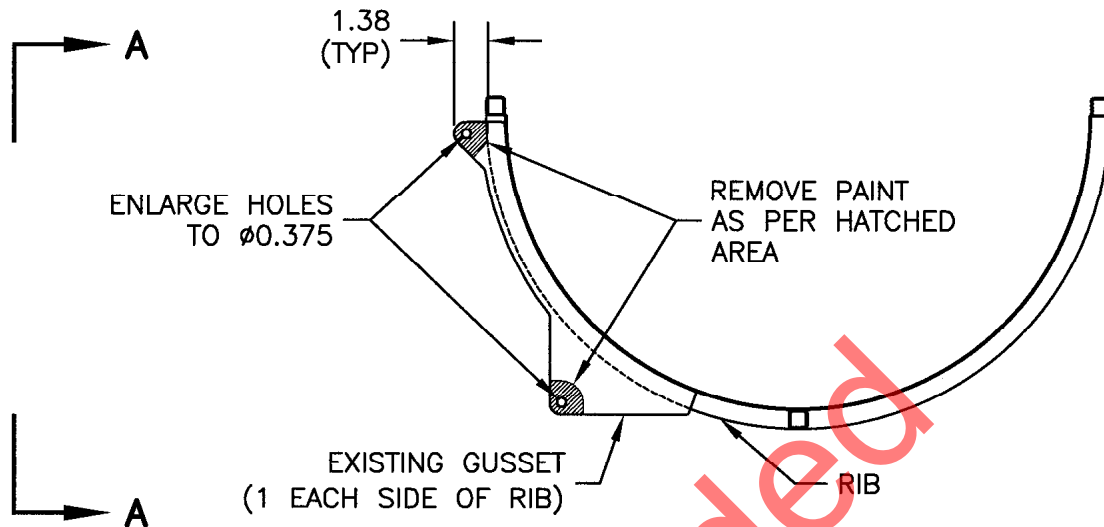
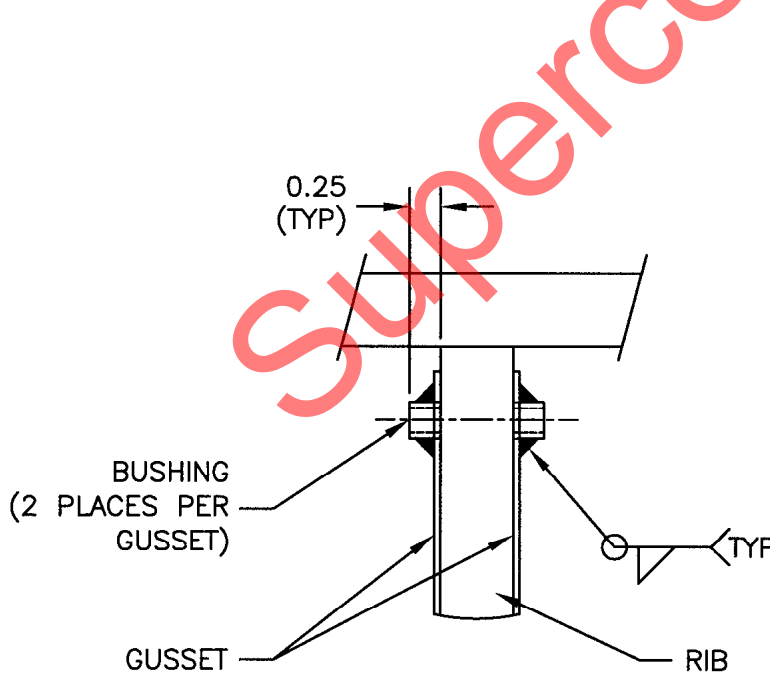
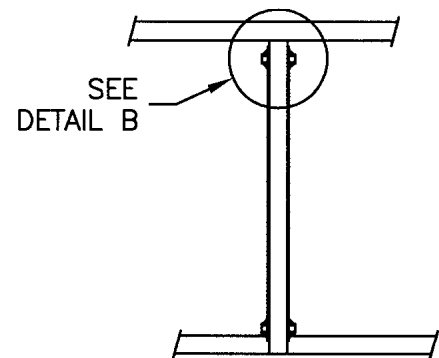
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**FIGURE 2: WELDING PREPARATION****DETAIL B****VIEW A-A: BUSHING  
INSTALLATION**

CANADA  
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